Blue

Work Order ID 55772

February 1, 2010 10:18:18 AM

Item ID: D3394-043 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Lug Assembly

Start Date: 1/29/10 **Start Qty:** 40.00 **Cust Item ID:**

Required Date: 2/08/10 **Req'd Qty:** 40.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** M **Date:** 10-2-01 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3394	**Revision Nbr** Rev A								
100	BAND SAW	0.00							
Bandsaw	**Memo**	0.00				40	∅		
Jeaspa Bandsaw	Cut Blank to .850"								
105 HAAS 1 ~~110~~	Outsource process - Machining	0.00				40	4		
Outsource5	~~Memo~~	0.00							
Outsource process - Machining	Send Blanks To:Metec/Mast Precision Machining☐P/O:_____ ☑Machine D3394-3 as per Dwg D3394								
QC 2 ~~120~~	Receive & Inspect for Damage & Mat'l Certs	0.00				40	4		
Packaging	**Memo**	0.00							
Packaging									

S.P 10/02/18

S.P 10/02/21

S.P 10/02/21

PTO

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3394-043 PAR #: _____ Fault Category: Machined part NCR: (Yes) No DQA: _____ Date: 10.03.04

Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: 10/03/04

NCR: 55772		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B: Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
10/02/21	105	4 part the origin was completly off on Y and X axis. R.C. During Powerup restart	CP 10.02.22 per QS1042	Qty 4 Replace B# 45800 Scrap + Destry qty x4	D.B 10/02/21	10.2.22	CP 10.02.22 per QS1042	10/03/02
		The machine get her zero at the wrong place. R.C: Machine Malfunction						

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 55772

February 1, 2010 10:18:18 AM

Item ID: D3394-043 **Accept** **Setup** **Start** **Stop**

Revision ID:

Item Name: Lug Assembly

Start Date: 1/29/10 **Start Qty:** 40.00 **Cust Item ID:**

Required Date: 2/08/10 **Req'd Qty:** 40.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC ~~Inspect dimensions to drawing~~ 2nd check	0.00							
QC	Memo	0.00				40	4		
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00				X40			
HandFinish	Memo	0.00							
Hand Finishing									
155		0.00							
SprayPaint	Memo	0.00							
Spray Painting									

10 · 2 · 22

10/02/22

10 02 25 40

Memo

Prime Delfleet Blue B 110918

Paint Delfleet Blue B 113171

Clear Delfleet B 113314

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 55772

February 1, 2010 10:18:18 AM

Item ID: D3394-043 **Accept** **Setup** **Start**

Revision ID: **Stop**

Item Name: Lug Assembly

Start Date: 1/29/10 **Start Qty:** 40.00 **Cust Item ID:**

Required Date: 2/08/10 **Req'd Qty:** 40.00 **Customer:**

Reference:

Run **Start**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
165	QC14- Inspect Spray Paint	0.00							
QC	**Memo**	0.00				ET	10-03-01		x40
Quality Control									
170		0.00							
Small Fab	Small Fab								
Small Fab	**Memo**	0.00				10/03/01			40
	Assemble as per Dwg D3394								
180	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									

S 10/03/02

counter x40

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 55772

February 1, 2010 10:18:18 AM

Item ID: D3394-043 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Lug Assembly

Start Date: 1/29/10 **Start Qty:** 40.00 **Cust Item ID:**

Required Date: 2/08/10 **Req'd Qty:** 40.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location:_____	0.00							
Packaging	**Memo**	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

10/3/02 (40)

10/03/03

mf
10-3-2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

February 1, 2010 10:18:22 AM

Work Order ID: 55772

Parent Item: D3394-043

Parent Item Name: Lug Assembly

Start Date: 1/29/10 **Required Date:** 2/08/10

Comments: IPP Rev: A New Issue 06-01-06 JLM

Start Qty: 40.00 **Required Qty:** 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS35489-93		Purchased	No			100	Each	118.0000	80.0000			
GROMMET												

Warehouse Location	Loc Qty	Loc Code	Qty Issued
Main Warehouse			
ST	118		
113288	18		16
113368	100		64

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2423		Manufactured	No			110	f	604.4578	2.9474			
Lug Extrusion												

Warehouse Location	Loc Qty	Loc Code	Qty Issued
Main Warehouse			
ST	604.4578379		
43722	175.629406		
44529	5.7731		
45800	423.055332		2.9474

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3394-3P		Purchased	No			170	Each	0.0000	40.0000			
Lug												

10/03/01

10/02/18

N/A

MADE IN HOUSE

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD	Work Order:	55772
Description: Lug	Part Number:	D3394-3
Inspection Dwg: D3394 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

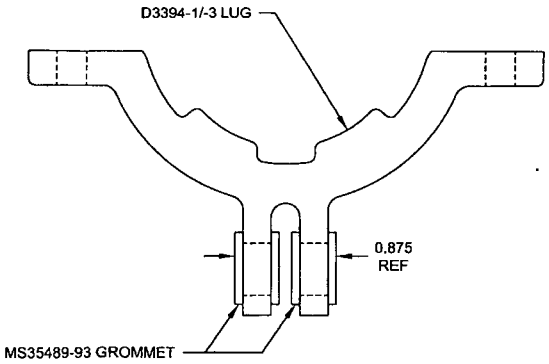
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.450	+/-0.010	4.457	✓			
0.345	+/-0.010	.337	✓			
0.306	+/-0.010	.310	✓			
3.700	+/-0.010	3.700	✓			
0.750	+/-0.010	.751	✓			
Ø0.257	+0.005/-0.000	Ø.260	✓			
Ø0.453	+0.006/-0.001	Ø.456	✓			
0.375	+/-0.010	.375	✓			
R1.100	+/-0.010	R1.104	✓			
0.400	+/-0.010	.400	✓			
0.250	+/-0.010	.260	✓			
1.91	+/-0.030	1.910	✓			
R0.060	+/-0.010	R.060	✓			

Measured by:	[illegible]	Audited by:	[illegible]	Prototype Approval:	N/A
Date:	10/02/18	Date:	10 · 2 · 22	Date:	N/A

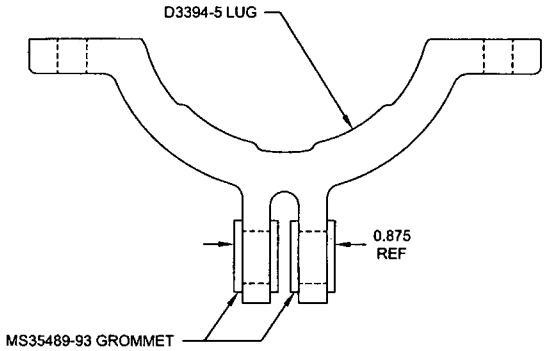
Rev	Date	Change		Revised by	Approved
A	09.11.04	New Issue	P/O D3394-043	KJ [illegible]	[illegible]

QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3394-041	LUG ASSEMBLY
	X		D3394-043	LUG ASSEMBLY
		X	D3394-045	LUG ASSEMBLY
1			D3394-1	LUG
	1		D3394-3	LUG
		1	D3394-5	LUG
2	2	2	MS35489-93	GROMMET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55772
BS1021-01



D3394-041/-043 LUG ASSEMBLY



D3394-045 LUG ASSEMBLY

DEO ATTACHED

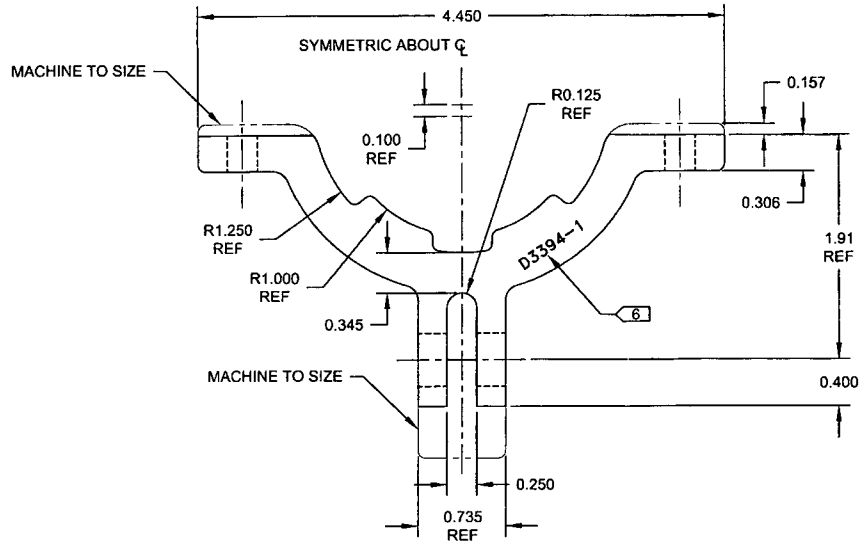
RELEASED
09/06/25 AD

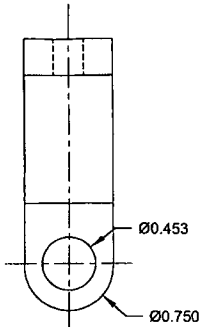
NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 0.20 lbs APPROX

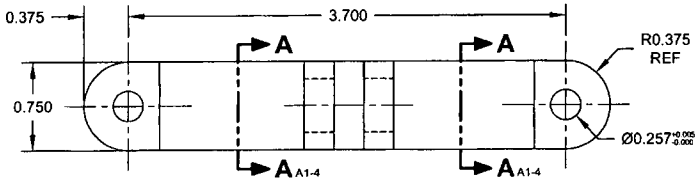
REV.	DESCRIPTION	BY	DATE
B	ADDED -045. SHT 4 ADDED FILLETS IN SECTION A-A. SEE PAR 152	AJS	09.04.02
A	NEW ISSUE	PH	05.02.14

DESIGN	PH	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3394	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG	NTS
DATE	09.04.02		

COPYRIGHT © 2005 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.







D3394-1 LUG

DEO ATTACHED

RELEASED 09/06/25

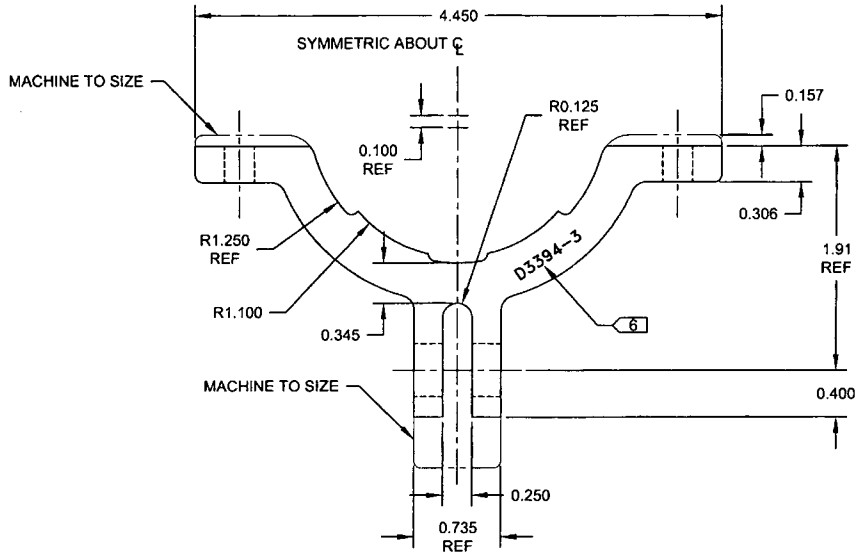
w/o 35712

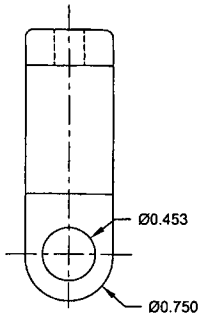
NOTES:

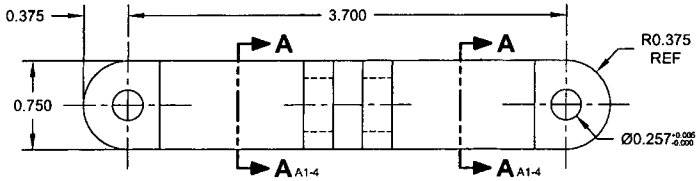
1) MATERIAL: MAKE FROM D2423
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
   POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION, WITH TOOL A TIP RADIUS OF 0.015±0.005
7) WEIGHT: 0.18 lbs

DESIGN	PH	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. D3394 — REV. B — SHEET 2 OF 4
MFG. APPR.		
APPROVED		TITLE: LUG — SCALE: NTS
DE APPR.		
DATE	09.04.02	

COPYRIGHT ©,2005 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT IS SUPPLIED, NOR TO BE REPRODUCED IN WHOLE OR IN PART WITHOUT THE PRIOR WRITTEN CONSENT OF DART AEROSPACE LTD.







D3394-3 LUG

DEO ATTACHED

RELEASED 09/25/25

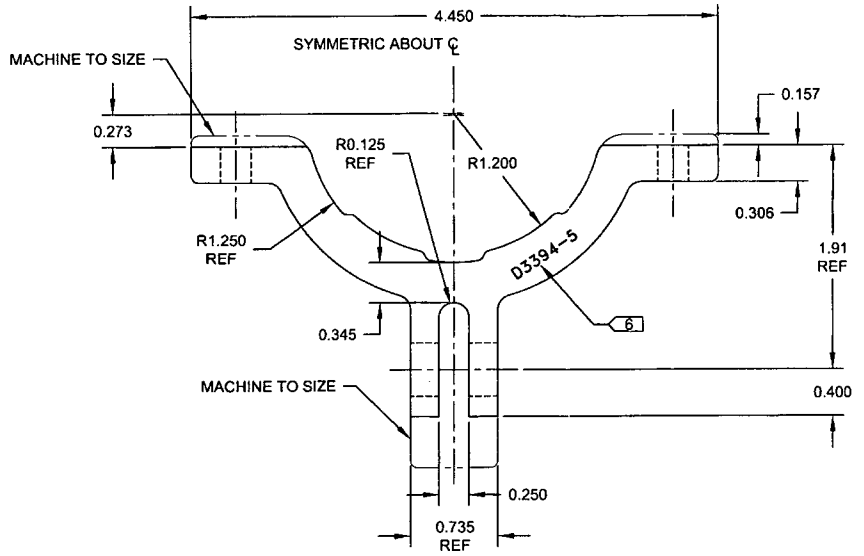
NOTES:

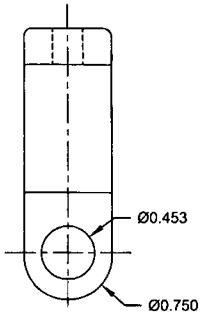
1) MATERIAL: MAKE FROM D2423
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
   POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION, WITH TOOL A TIP RADIUS OF 0.015±0.005
7) WEIGHT: 0.18 lbs

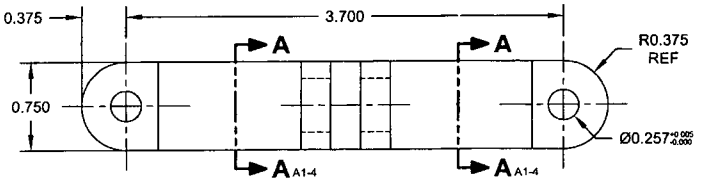
W/O 55772

DESIGN	PH	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	A.S	
CHECKED		DRAWING NO. D3394 — REV. B — SHEET 3 OF 4
MFG. APPR.		
APPROVED		TITLE: LUG — SCALE: NTS
DE APPR.		
DATE	09.04.02	

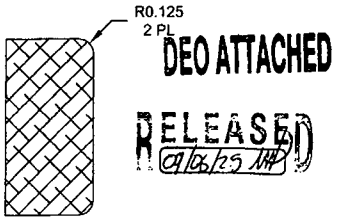
COPYRIGHT © 2005 BY DART AEROSPACE LTD







D3394-5 LUG



SECTION A-A B5-2 B4-2 B5-3 B4-3 B5-4 B4-4

NOTES:

1) MATERIAL: MAKE FROM D2423
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
   POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION, WITH TOOL A TIP RADIUS OF 0.015±0.005
7) WEIGHT: 0.18 lbs

W055772

DESIGN	PH	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. D3394 — REV. B — SHEET 4 OF 4
MFG. APPR.		
APPROVED		TITLE: LUG — SCALE: NTS
DE APPR.		
DATE	09.04.02	

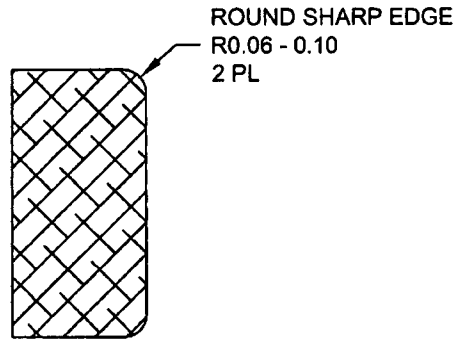
COPYRIGHT © 2005 BY DART AEROSPACE LTD

W/O 55772

DRAWING NO.	TITLE	REV. B	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO.	SHEET NO.	SCALE
D3394	LUG			D3394-B-1	SHEET 1 OF 1	NTS
DRAWN AJS	CHECKED		MFG. APPR.	APPROVED	DE APPR.	
DATE 09.11.04	DATE 09.11.04		DATE 09-11-04.	DATE 09/11/04	DATE 09/11/04	

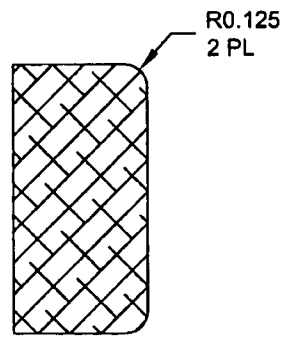
SHEET 4 ZONE A,1 MODIFY SECTION A-A AS SHOWN:

IS:



SECTION A-A

WAS:



SECTION A-A

RELEASED
2009 -11- 25

REASON: DRAFTING ERROR

COPYRIGHT © 2009 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.